

Work Order ID . 65468

January 18, 2011 10:30:27 AM



Page 1

Item ID:	D3481-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Shut-off Valve Bracket					
Start Date:	1/18/11	Start Qty: 2.00 ⁵		Cust Item ID:		
Required Date:	1/31/11	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>CL</u>	Date: <u>1/10/11</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3481	Rev B								
100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D3481								
110		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
	Identify as per dwg & Stock Location: <u>062</u>								
Packaging	Memo	0.00							
Packaging									

1/5/11/02/01 (5)

84102101

(X)

1/11/02/01 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3481-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Shut-off Valve Bracket

Start Date: 1/18/11 Start Qty: 2.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/02 JJ

PL 11-02-1
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 65468

Parent Item: D3481-041

Parent Item Name: Shut-off Valve Bracket





Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A New Issue 06-02-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-3A  Bolt		Purchased	No				Each	265.0000		8			
<div> <div>Location</div> <div>ST350</div> <div>116400</div> <div>116419</div> <div>116590</div> </div> <div> <div>Loc Qty</div> <div>265</div> <div>65</div> <div>150</div> <div>50</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
AN960-10  Washer	NAS1149F0363P	Purchased	No				Each	7,877.000		8			
<div> <div>Location</div> <div>ST348</div> <div>19356</div> <div>5519</div> </div> <div> <div>Loc Qty</div> <div>7877</div> <div>200</div> <div>7677</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
BACN10YD3  CLIP FLOATING NUT		Purchased	No				Each	48.0000		8			
<div> <div>Location</div> <div>ST283</div> <div>100977</div> <div>101144</div> </div> <div> <div>Loc Qty</div> <div>48</div> <div>28</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3481-043  Bracket & Clamp Assembly		Manufactured	No				Each	0.0000		2			

B 65487

EPB11/02/01

11

9

EPB11/02/01

20

EPB11/02/01

20

EPB11/02/01

20

EPB11/02/01

20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

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Work Order ID: 65468



Parent Item: D3481-041



Parent Item Name: Shut-off Valve Bracket

Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 2.00

Required Qty: 2.00

D3481-1

Manufactured No

Each

1.0000



Angle Bracket



²
1/18/11

Location

Loc Qty

Loc Code

ST065

1

34406

1

1
B65488 (4X)

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

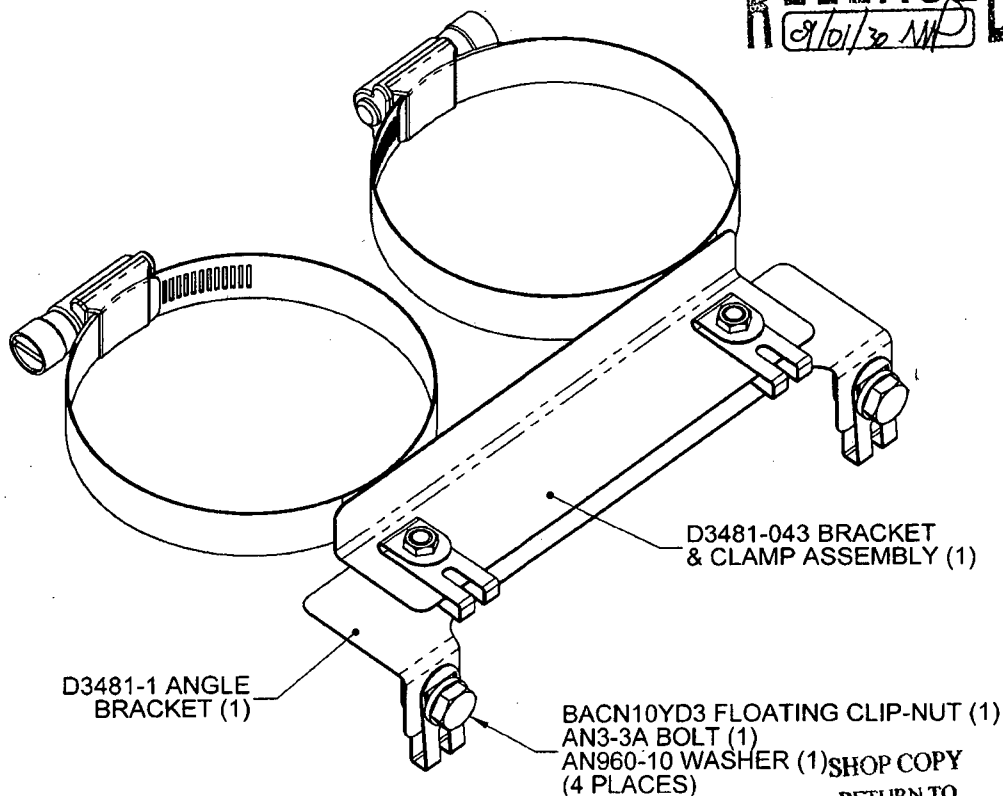
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. B SHEET 1 OF 4
DATE 08.12.19		TITLE SHUT-OFF VALVE BRACKET	SCALE 2:3
A	06.01.23	NEW ISSUE	
B	08.12.19	QS20052S WAS QS20056S (SHT 2); MATL SPEC WAS MIL-S-5019	

RELEASED
9/01/30 M/P



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WORK ORDER

D3481-041 SHUT-OFF VALVE BRACKET

- 1) IDENTIFY WITH DART P/N D3481-041 USING FINE POINT PERMANENT INK MARKER

NO. 65468

CL 11/01/18

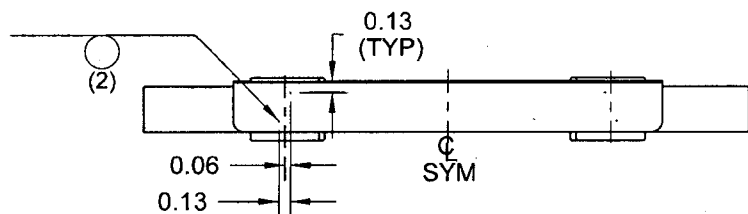
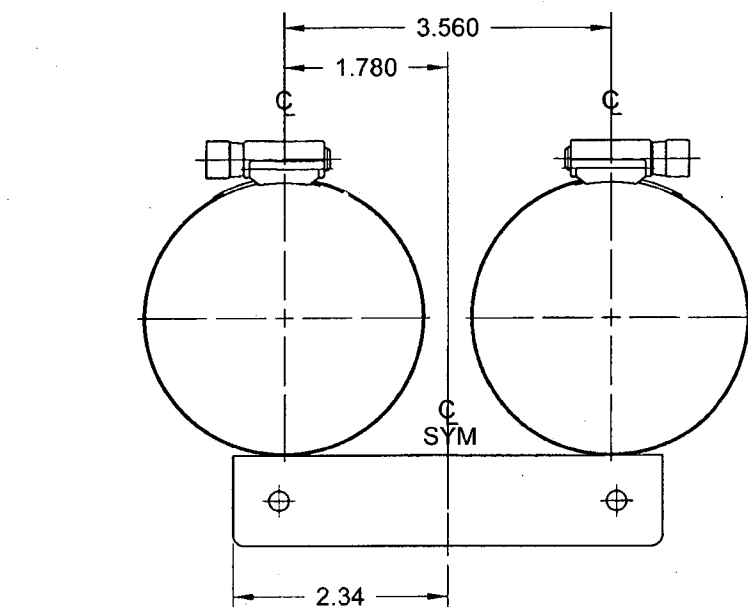
QTY -041	P/N	DESCRIPTION
X	D3481-041	SHUT-OFF VALVE BRACKET
1	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-1	ANGLE BRACKET
4	AN3-3A	BOLT
4	AN960-10	WASHER
4	BACN10YD3	FLOATING CLIP-NUT


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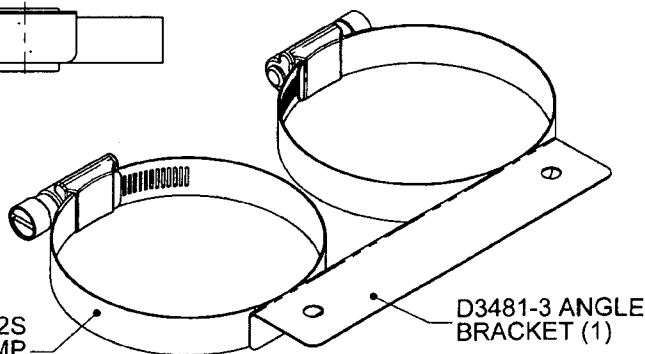
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DATE 08.12.19		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



 QS20052S
AERO-SEAL CLAMP
(2 PLACES)



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WORK ORDER
NO. 65468

D3481-043 BRACKET & CLAMP ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 034
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010



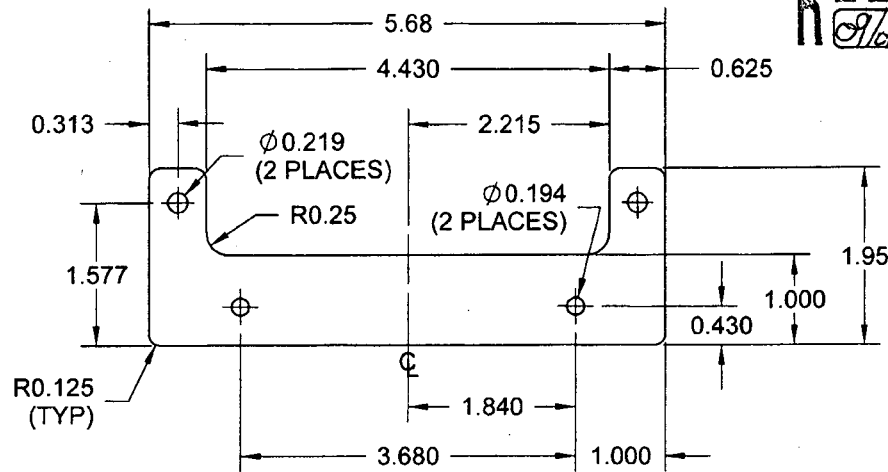
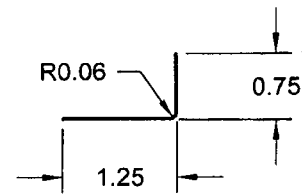
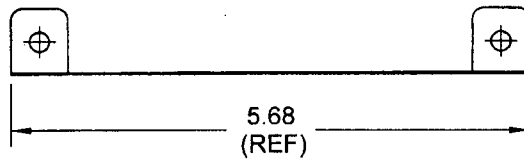
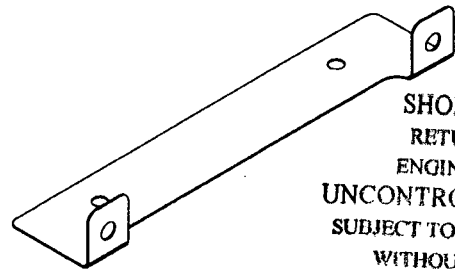
QTY -041	P/N	DESCRIPTION
X	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-3	ANGLE BRACKET
2	QS20052S	AERO-SEAL CLAMP

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. B SHEET 3 OF 4
DATE 08.12.19		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

**D3481-1F FLAT PATTERN****D3481-1 ANGLE BRACKET**

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NO. 65468

NOTES:

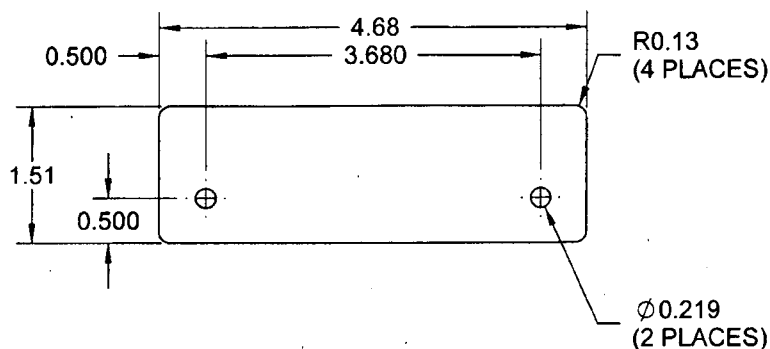
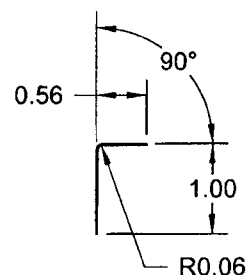
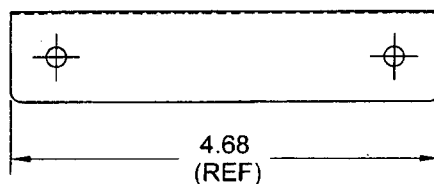
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. B SHEET 4 OF 4
DATE 08.12.19		TITLE SHUT-OFF VALVE BRACKET SCALE 1:2	

RELEASED
07/01/30 *[Signature]***D3481-3F FLAT PATTERN****D3481-3 ANGLE BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH \triangle_B
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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